

Work Order ID 68504

Page 1

Thursday, April 14, 2011 10:20:20 AM

Item ID: D4004-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Bottom Strap Attach Bracket

Start Date: 4/14/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 4/27/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan: CLDate: 11/04/14

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4004

A

100

0.00



BAND SAW

Bandsaw

Memo

0.00

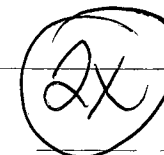
Jeaspa Bandsaw

1-Cut D3033-144 extrusion to length per D4004-5 detail of dwg D3033

Ensure cut is started at correct place per dwg

Batch:

2-Deburr

B58045=> m.k 11/04/15

105

0.00



Small Fab

Memo

0.00

Small Fab

Drill and c'sink holes as per dwg and trim part to length as required.

=> m.k 11/04/15

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Work Order ID 68504

Thursday, April 14, 2011 10:20:21 AM



Page 2

Item ID: D4004-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Bottom Strap Attach Bracket

Start Date: 4/14/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 4/27/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

ml 11 04 15 (2)

120

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

2 0 11 04 15

130

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

2 BR 11-4-18.

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 68504

Thursday, April 14, 2011 10:20:21 AM



Page 3

Item ID: D4004-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Bottom Strap Attach Bracket

Start Date: 4/14/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 4/27/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

Identify as per dwg & Stock Location: 106

0.00





Packaging

Memo

0.00

Packaging

11/4/19  

150

QC21 - Final Inspection - Work Order Release

0.00

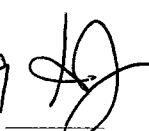


QC

Memo

0.00

Quality Control

11/4/19 

11/6/04.19

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, April 14, 2011 10:20:18 AM

Page 1

Work Order ID: 68504

Parent Item: D4004-5

Parent Item Name: Bottom Strap Attach Bracket



Start Date: 4/14/2011

Required Date: 4/27/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP rev A 09.12.15 new issue EC verified by:DD
10.05.17 as per ECN10-562 DD verf:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3033-144

Manufactured

No

100

Each

9.5600

0.41

0.863158



Seat Track

Location

Loc Qty

Loc Code

ST489A

9.56

30209

0.5

58045 ✓

9.06

M-L 11/04/15

0.863158

~~*~~

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

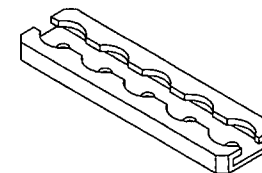
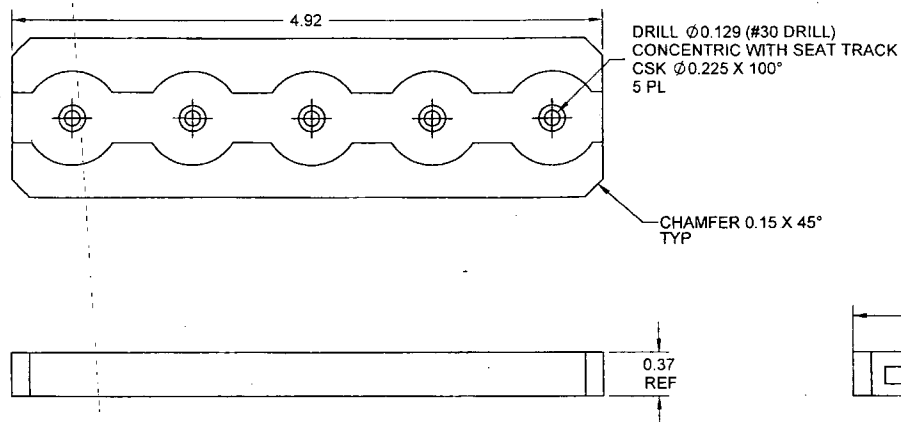
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4004-5	JCA-M47-2-23



D4004-5 BOTTOM STRAP ATTACH BRACKET

RELEASED
2010-05-05
W

NOTES:

- 1) MATERIAL: MADE FROM ANCRA P/N 40456-11-144 OR BROWNLIN P/N 20276-144-0-0 OR D3033-144
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4004-5" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.14 lbs

CL4104114
W10:62504

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4004	REV. A
MFG. APPR.			SHEET 7 OF 11
APPROVED		TITLE SIDE RESTRAINT	SCALE
DE APPR.			NTS
DATE	10.02.10	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	